

Date: Monday, 7/9/2007 11:39:50 AM
 User: Kim Johnston

Process Sheet

SPhiT-2

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP (CASTING DETAIL)		
Job Number	: 33321-2			Part Number	: D25763		
Estimate Number	: 10510			Drawing Number	: D2576 REV E		
P.O. Number	:			Project Number	: N/A		
This Issue	: 7/9/2007 S.O. No. :			Drawing Revision	: G		
Prsht Rev.	: NC			Material	:		
First Issue	: 7/6/2007 Type : PURCHASED PARTS			Due Date	: 7/24/2007 Qty: 100 Um: Each		
Previous Run	: 31925						
Written By	:						
Checked & Approved By	:						
Comment	: Est: E 02.08.19			Consolidated D2576-1 and D2576-3 KJ/RF			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	D25761	Step (Casting Detail)
Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s) Pick: Qty Part# Description Batch 1 D2576-1 Step (Casting Detail) <u>Step (Casting Detail)</u>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS1 1- Machine as per Folio FA332 and Dwg D2576 2- Deburr		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>BARCLAY</u> <u>PC-8/2/07 (75)</u>		

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Drawing Name: STEP (CASTING DETAIL)

Job Number: 33321

Part Number: D25763

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1/9/07/06

Job Completion



2007/2/05

75

W

DART AEROSPACE LTD	Work Order:	
Description: Step	Part Number:	D2576-3
Inspection Dwg: D2576	Rev: E17	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

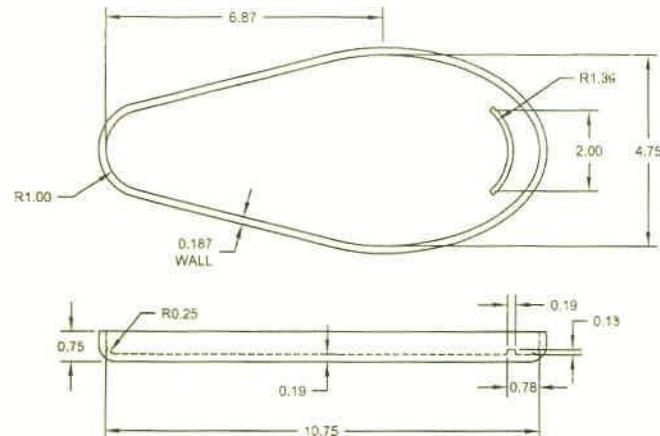
Measured by:	BS-154
Date:	08/01/13

Audited by:	<i>Dan</i>
Date:	08/13/2013

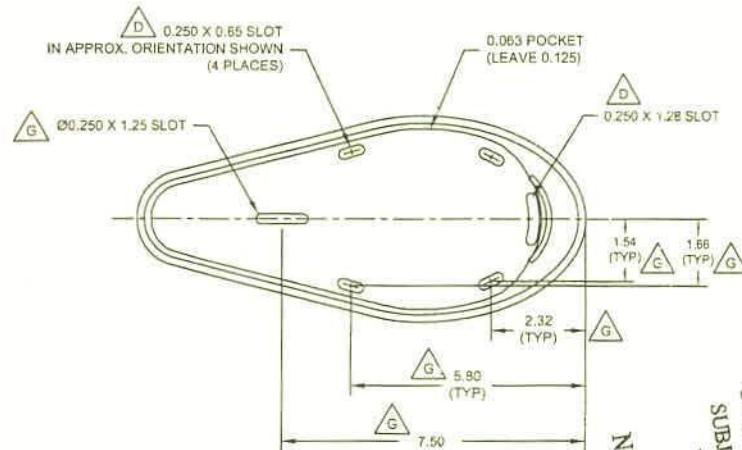
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.10	New Issue	KJ/RF	++

8 7 6 5 4 3 2 1



D2576-1 CASTING



D2576-3 MACHINING DETAIL
(MAKE FROM D2576-1)

A NOTES:

- 1) MATERIAL: CAST ALUMINUM ALLOY A-535.2
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.025 TO 0.050 MAX
- 6) IDENTIFICATION: NONE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33321

8 7 6 5 4 3 2 1

RELEASED
07.08.24

G	- CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM	
	MB	07.08.15
F	PH	07.04.17
E	RF	99.09.07
D	CP	99.08.18
C	DS	98.08.18
B	DS	96.11.28
A	DS	96.09.18
REV.	DESCRIPTION	BY DATE
DESIGN	1	DART AEROSPACE LTD
DRAWN	1	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	REV. G
MFG. APPR.	21	DRAWING NO. D2576
APPROVED	1	SCALE
DE APPR.	1	STEP 1.3
DATE	07.08.15	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT BE NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/01 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/01/01	2.0	Parts move when machining R.C. Part is made of CAST AND WAS not often flat enough	<input checked="" type="checkbox"/>	SCRAP and Destory no replace Qty <input checked="" type="checkbox"/>	S-F 08/01/01	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
		Flat enough				08/02/01	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
08/02/01	# 2.0	# one casting was not within flat. (off by 0.05) and cause it to be machined 0.050 "skewed"	<input checked="" type="checkbox"/> 08.02.01 PV	SCRAP and Destory no replace Qty <input checked="" type="checkbox"/>	<input checked="" type="checkbox"/> 08.02.01 PV	<input checked="" type="checkbox"/> 08/02/01	<input checked="" type="checkbox"/> 08/02/01 PV	<input checked="" type="checkbox"/> 08/02/01

NOTE: Date & initial all entries

R.C. Casting

